

REPLACEMENT SHEET  
Customer No.: 52,054  
Serial No.: 10/568,552  
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#### ABSTRACT OF THE DISCLOSURE

In a consumable electrode type welding method, while feeding a welding wire 1, a welding torch 4 is moved by a robot manipulator 9 in a direction where the welding torch 4 is pulled apart from a base metal 7, so that an initial arc is generated while the welding wire 1 is separated from the base metal 7. This not only can eliminate the need for the reversing operation of the robot manipulator 9 and thus can reduce the waste time to thereby be able to reduce a tact time but also can stabilize an arc in the welding start portion and thus can reduce the “unexpected stop” effectively.